

# Work Order ID 126191

**\*126191\***

October-31-14 11:50:39 AM

Page 1

Item ID: D2807-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Gas Spring  
 Start Date: 10/31/14 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 11/07/14 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan: CL Date: 14/11/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2807	Rev E								
100	PURCHASING	0.00							
<b>*100*</b>									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>26348</u> Order as per Dwg D2807Possible supplier:Lift Support Technologies,Saskatoon,CanadaP/N 6/15-164/50-115N								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

CL 14/11/03 24

24x 8P14-11-5

(24)

DAS  
38  
9-89  
NOV 06 2014

## Page 2

October-31-14 11:50:39 AM

**Item ID:** D2807-041

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Gas Spring

Stop **\*NS2\***

**Start Date:** 10/31/14      **Start Qty:** 24.00

**\*24\***

**Cust Item ID:**

**Required Date:** 11/07/14      **Req'd Qty:** 24.00

**\*24\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

[illegible]

**Work Order ID 126191**

October-31-14 11:50:39 AM

**\*126191\***

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Item ID: D2807-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Gas Spring  
Start Date: 10/31/14 Start Qty: 24.00 **\*24\*** Cust Item ID:  
Required Date: 11/07/14 Req'd Qty: 24.00 **\*24\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

14/11/10 *[Signature]*

*[Signature]* 11-07

# Picklist Print

October-31-14 11:50:38 AM

Page 1

Work Order ID: 126191

**\*126191\***

Parent Item: D2807-041

**\*D2807-041\***

Parent Item Name: Gas Spring

Start Date: 10/31/14

Required Date: 11/07/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD  
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N		Purchased	No			130	Each	0.0000	1	24			
<b>*6/15-164/50-115N*</b>									<b>**</b>				
Gas Spring													
D3671-1		Manufactured	No			110	Each	25.0000	1	24			
<b>*D3671-1*</b>									<b>**</b>				
Placard													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST055	25						
						120617	25						

24 x SP 14-11-5

14/11/06

DAS  
36  
9-89

24

# **SPECIFICATION CONTROL DRAWING**

CL1411103  
W/O: 126191

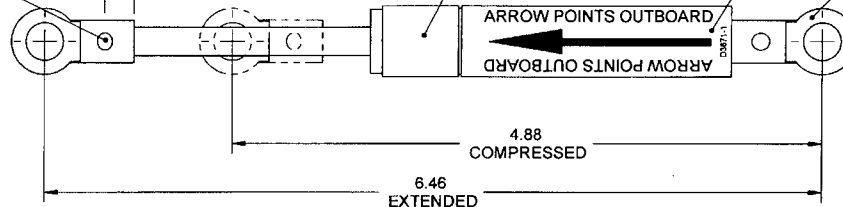
(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH Ø0.375 TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG

0.24 TO CRIMP  
(TYP)

D2807-5  
OR  
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS



**D2807-041 GAS SPRING**

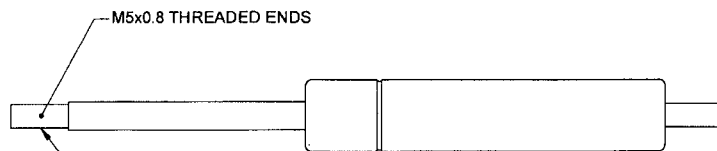
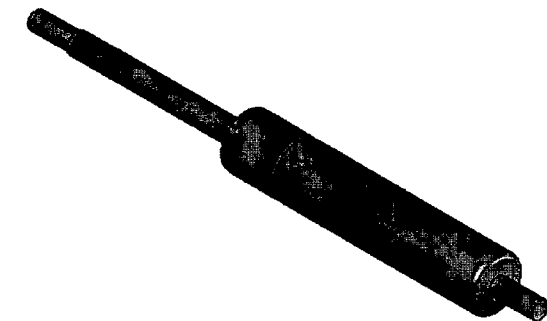
## **D2807-041 GAS SPRING ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

### **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)  
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWS	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2807	SHEET 1 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

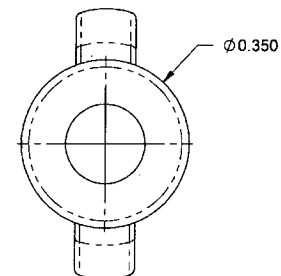
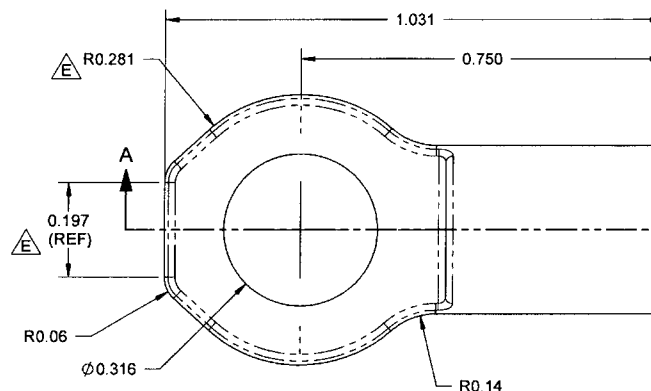
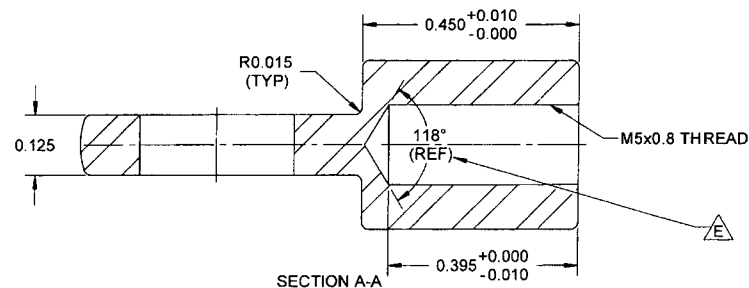


ACCEPTABLE TO TRIM ENDS UP  
TO 0.050 TO MEET D2807-041  
COMPRESSED DIMENSION  
(TYP)

**D2807-1 GAS SPRING**  
SCALE 1:1

**D2807-1 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(P/N SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS

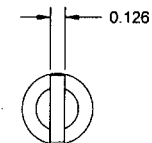
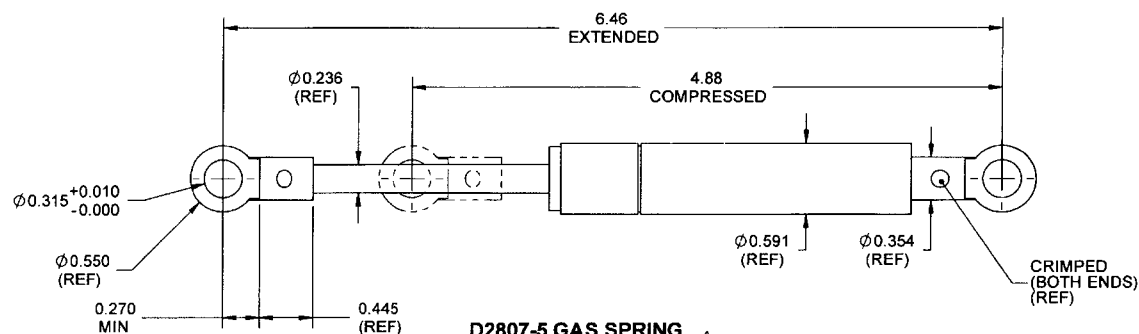


**D2807-3 LUG**

**D2807-3 LUG NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	LF	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.		TITLE <b>GAS SPRING</b>	SHEET 2 OF 3
APPROVED		SCALE 4:1	
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	07.12.28	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D2807-5 GAS SPRING**

**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA  
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,  
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.	KE	TITLE <b>GAS SPRING</b>	SCALE 4:1
APPROVED	KE	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	KE		
DATE	07.12.28		

RELEASED  
06.02.2000



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO26348**

Purchase Order Date 11/3/2014

PO Print Date 11/3/2014

Page Number 1 of 1

**Order From :**

VC-LST0001

LS TECHNOLOGIES INC.  
314 JESSOP AVE  
SASKATOON, SK S7N 1Y6  
CA

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 306 683 5000

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx Overnight collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms** Net 30

**Currency** CAD

**FOB** EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6/15-164/50-115N  AS PER DWG D2807 REV. E B126191	Gas Spring	11/7/2014 Yes 11/7/2014		24.00 Each	\$63.90	\$1,533.60
SP14-11-5							
Line Total:							\$1,533.60
2	71401-45  Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	11/7/2014  No 11/7/2014		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$1,533.60

**PO Instructions:** Fedex Acc#151793240

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Change Nbr:** 1

**Change Date:** 11/3/2014



LS Technologies Inc  
314 Jessop Ave  
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

# Packing Slip


P.O. No.	Date	Invoice #
26348	11/04/2014	11918

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
9/18/2014	Fed-Ex	

Qty	Description
24	D2807-041 B126191 Stainless Gas Spring  Shipping Via FED EX Tracking # 771738263900  SP14-11-5.

Order checked by: 



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

**Certificate of Conformance**

Nov 4, 2014

This is to certify that the parts listed below meets specifications as required by your order.

**24 Units : D2807-041 B126191 Stainless Gas Spring**

**Country of Manufacture : Canada**

**Date of Manufacture : March 2014**

**This product is ROHS compliant.**

**Purchase Order # 26348**

**Inv# 11918**

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr  
President